

Work Order ID 79491

Thursday, January 26, 2012 2:04:30 PM

79491

RUSH

Page 1

Item ID: D3340-13

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Aft Skidtube Protector

Start Date: 1/26/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 1/27/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan: *MF*Date: *12-01-25* Tooling:

Date:

Run Start ***NR1***

QC:

Date: SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3340	Rev B								

100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3340 Dwg Rev: *B* Prog Rev: *B* 2-
Deburr if necessary*B12-1-27**(4)*

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

B12-1-27

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

*5126127**(4)*

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

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Page 2

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N900040100

Setup Start

NS1

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Item Name: Aft Skidtube Protector

Stop

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

130

Brake NC

Brake NC

NC BRAKE

Memo

0.00

Deburr if necessary Form on brake as per Dwg D3340 using Jigs DT 8326 and DT8261

SP 12/01/30

4

140

140

QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

S 12/01/30

40

150

150

Powdercoat

Powder Coating

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

Memo

0.00

START TIME:

8-20

OVEN TEMPERATURE:

FINISH TIME:

32001

8-50

4X M-12/01/30

M118489

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Page 3

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4

Cust Item ID:

Required Date: 1/27/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC3- Inspect Part Finish

0.00

160

QC

Memo

0.00

Quality Control

4x d M 12/11/30
counted.

170

Identify as per dwg & Stock Location 500

0.00

170

Packaging

Memo

0.00

Packaging

12/11/30

180

QC21- Final Inspection - Work Order Release

0.00

180

QC

Memo

0.00

Quality Control

12/11/30

12/20/30
H

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Picklist Print

Thursday, January 26, 2012 2:04:30 PM

Page 1

Work Order ID: 79491

Parent Item: D3340-13

Parent Item Name: Aft Skidtube Protector

Start Date: 1/26/2012

Required Date: 1/27/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP: A 05.11.10 Preliminary issue AP/EC
IPP Rev:B Now on Waterjet 06-10-06 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M1010S20GA 1010/1025 SHEET		Purchased	No			110	sf	121.7000	1.258	5.2968421			

B12-1-27

Location

Loc Qty

Loc Code

MAT019

121.7

111410

45.2

116791

76.5

116791

(4)

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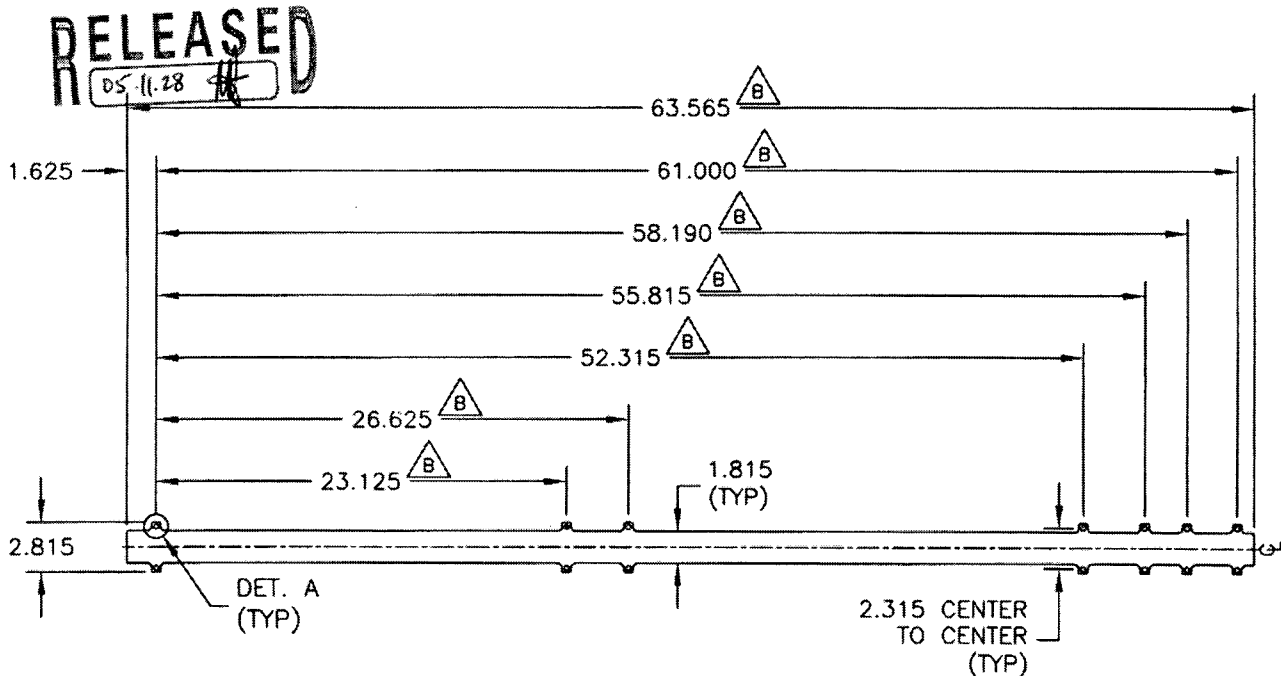
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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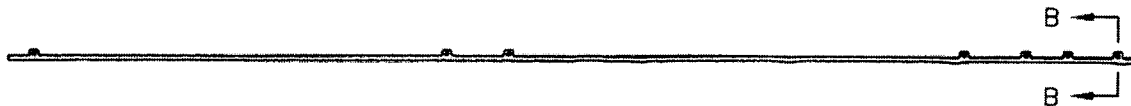
NOTE: Date & initial all entries



DESIGN MB	DRAWN BY MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3340	REV. B SHEET 6 OF 11
DATE 05.11.22	TITLE SKIDTUBE PROTECTOR		SCALE 1:10



D3340-13F FLAT PATTERN



D3340-13 AFT SKIDTUBE PROTECTOR

NOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES COLD ROLLED STEEL 19 GAUGE (0.040 THICK)
- 2) PART IS SYMETRICAL ABOUT CENTER LINE
- 3) FINISH: POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP CORNERS 0.063 MAX

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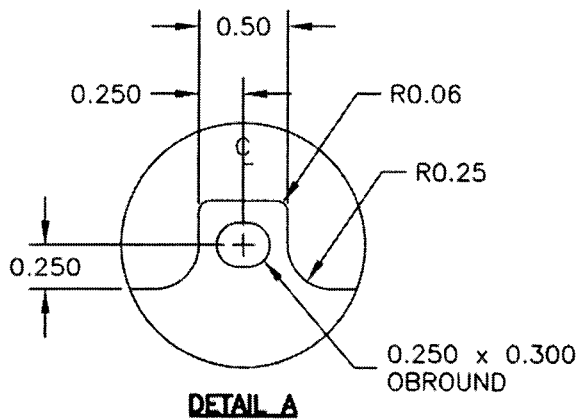
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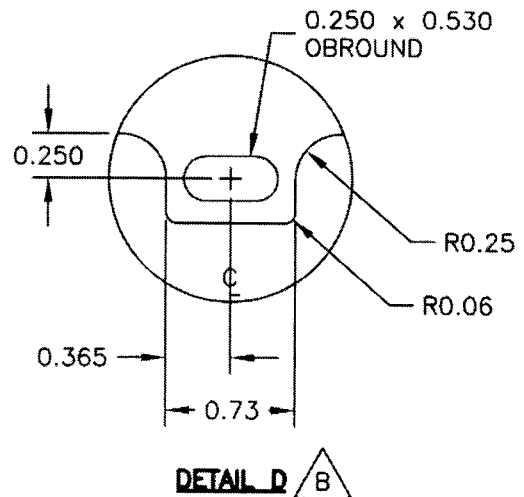
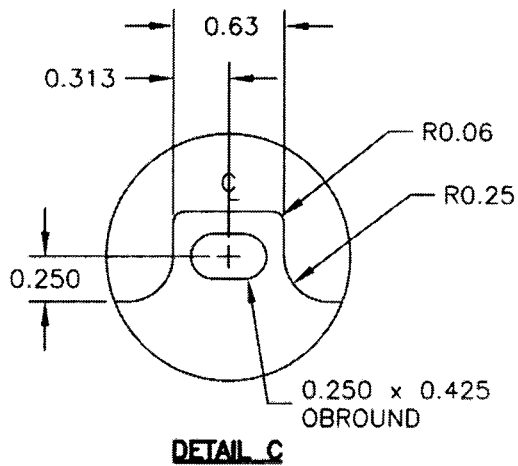
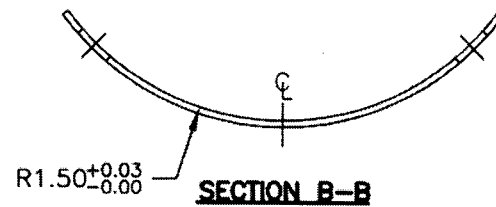
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DESIGN MB	DRAWN BY MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3340	REV. B SHEET 11 OF 11
DATE 05.11.22		TITLE SKIDTUBE PROTECTOR	SCALE 1:1



RELEASED
05-11-28 #



79491

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DART AEROSPACE LTD		Work Order: 79991
Description: Aft Skidtube Protector		Part Number: D3340-13
Inspection Dwg: D3340	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.250	+/-0.010	.251	2		V B67	
0.300	+/-0.010	.303	2		V	
0.50	+/-0.030	.497	2		V	
0.250	+/-0.010	-.251	2		V	
2.315	+/-0.010	2.311	2		V	
2.815	+/-0.010	2.821	2		V	
1.825	+/-0.010	1.825	2		V	
23.125	+/-0.010	23.125	1		T B61	
26.625	+/-0.010	26.625	1		T	
52.315	+/-0.010	52.315	1		T	
55.815	+/-0.010	55.815	1		T	
58.190	+/-0.010	58.190	1		T	
61.000	+/-0.010	61.000	2		T	
63.565	+/-0.010	63.565	2		T	
0.040	+/-0.010	.037	2		V	

Measured by: RB	Audited by: S	Preliminary Approval:
Date: 12-1-27	Date: 12/4/27	Date:

Rev	Date	Change	Revised by	Approved
A	10.06.07	New Issue	KJ	

Dart Aerospace Ltd

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